

Work Order ID 61222

August 11, 2010 11:03:26 AM



Page 1

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/8/11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2332	Rev C1

100

0.00



Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

=> m, L 10/08/18

(6X)

110

0.00



Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

=> m, L 10/08/18

(6X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

= 7 m, 10/08/18
LB 10-9-14

(6X)

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

D2332-5 - 8/10/08/18 x6

D2332-7 - 8/10/08/19 x6

D2332-11 - 8/10/08/19 x6

D2332-13 - 8/10/08/19 x6

(46)

8/10/08/19

140

0.00



Large Fab

Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M108/60

EL 10-9-1 (46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 8/25/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		<i>10.09.08</i> <i>10.09.08</i>		<i>6</i> <i>6</i>	<i>0</i>		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>10/09/09</i>		<i>6</i>			
170 Small Fab Small Fab	 Memo 1- Tumble 2- Assemble as per dwg D2332	0.00 0.00							

10-9-14
ES 10/09/14 *6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/09/15

0.00

Memo

(46)

190



Packaging

Packaging

Identify as per dwg & Stock Location: 5/2

0.00

0.00

Memo

10/15/10 (6)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/09/15

ME

10-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

August 11, 2010 11:03:25 AM

Page 1

Work Order ID: 61222

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.250		Purchased	No			100	f	37.1895	0.1	0.631579			
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304 SS Round bar .250

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	24	
114482	24	
MAT028	13.189468	
107387 ✓	13.189468	

m.k
10/08/18

0.631579

M304TR1.000W.049		Purchased	No			100	f	30.8416	0.43	2.715789			
------------------	--	-----------	----	--	--	-----	---	---------	------	----------	--	--	--



304 RD Tube 1.00 x .049W

Location	Loc Qty	Loc Code
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MAT018	30.841584	
108756	10.08	
111457 ✓	20.761584	

m.k
2.715789 w/08/18

2.715789

M304TR0.500W.035		Purchased	No			110	f	129.4902	1.25	7.894737			
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304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code
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MAT	109.525397	
114482 ✓	85.797247	
115180	23.72815	
MAT014	19.96082	
114356	19.96082	
MAT017	0.004	
112800	0.004	

7.894737

m.k
w/08/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

August 11, 2010 11:03:25 AM

Work Order ID: 61222



Parent Item: D2332-041



Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

AN4-4A
Bolt

Purchased No

170 Each

210.0000

1

6



8/5/10/09/14

Location

Loc Qty

Loc Code

ST356

200

114615

200

ST361

10

108138

2

111295

8

6

AN960JD416L
Washer

NAS1149D0416J Purchased No

170 Each

335.0000

3

18



8/5/10/09/14

Location

Loc Qty

Loc Code

ST346

335

106785

72

110153

263

18

MS21042L4
Nut

Purchased No

170 Each

3,257.000

1

6



8/5/10/09/14

Location

Loc Qty

Loc Code

ST300

3257

113422

68

114523

28

114718

16

114784

1145

115108

2000

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

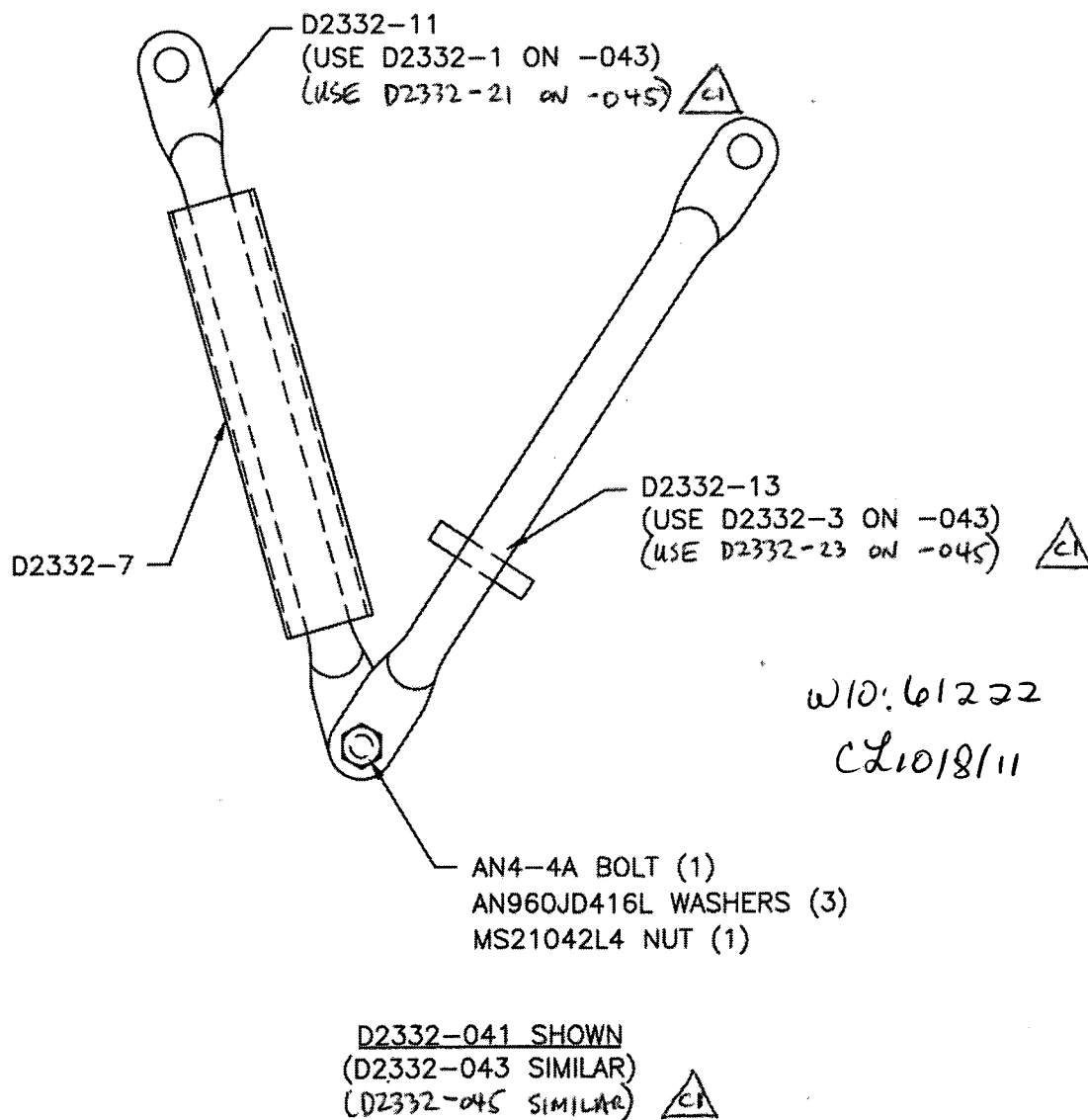
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	





RELEASED
03.07.04 *[Signature]***Copyright © 1994 by DART AEROSPACE LTD**

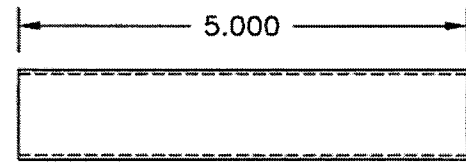
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6.690
2.60
6.950

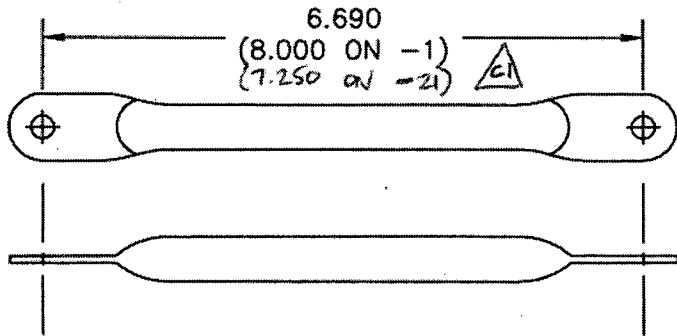
DART

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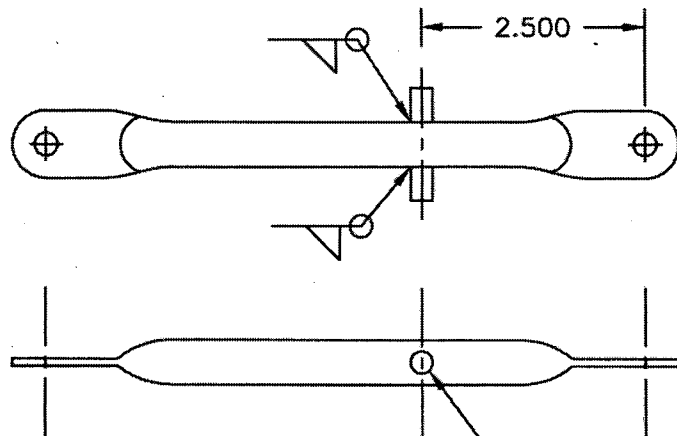
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED 	APPROVED 	DRAWING NO. D2332	SHEET 2 OF 2	
DATE 03.07.03	TITLE LID PROP ASSEMBLY		SCALE 1:2	
C	 03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (ORT)		
C1	 03.08.06	ADD -045 PROP 7.25" LONG		



D2332-7 LOCKING COLLAR



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

CI

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.01.04

28 10/8/11
210:61222